

Date: Tuesday, 5/16/2006 10:41:13 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 27152		Part Number	: D28073		
Estimate Number	: 10337		Drawing Number	: D2807, REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/16/2006 S.O. No. : N/A		Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/30/2006 Qty: 50 Um: Each		
Previous Run	: 26757		Comment	: Est A 05.06.02 New Issue KJ/JLM		
Written By	: See <u>all</u> comment below		Comment	: 06.05.16 w		
Checked & Approved By	: _____		Comment	: _____		
Comment	: Est A 05.06.02 New Issue KJ/JLM		Comment	: _____		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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Comment: Qty.: 0.1094 f(s)/Unit Total : 5.4705 f(s)

Material: 303 Round Bar Ø0.750"  
(M303R0.750)

Batch: M100806

MS 06/05/29

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE

Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

MS 06/05/29 50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/05/29 50

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1

Machine as per Folio FA528 and Dwg D2807 Dwg Rev: W/06/02  
Folio Rev: N/A Machined Manually

2-Deburr

MS 06/06/09 50

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/06/09 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

DQA: *D*Date: *06/06/13*

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: LUG
Job Number: 27152		Part Number: D28073
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC8 	SECOND CHECK 
Comment: SECOND CHECK		SD 06.06.09
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>57387</i>		<i>66/12/s (50)</i>
8.0	DC 	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		<i>SD 06.06.09 (50)</i>
Job Completion 		<i>u 06.06.13</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

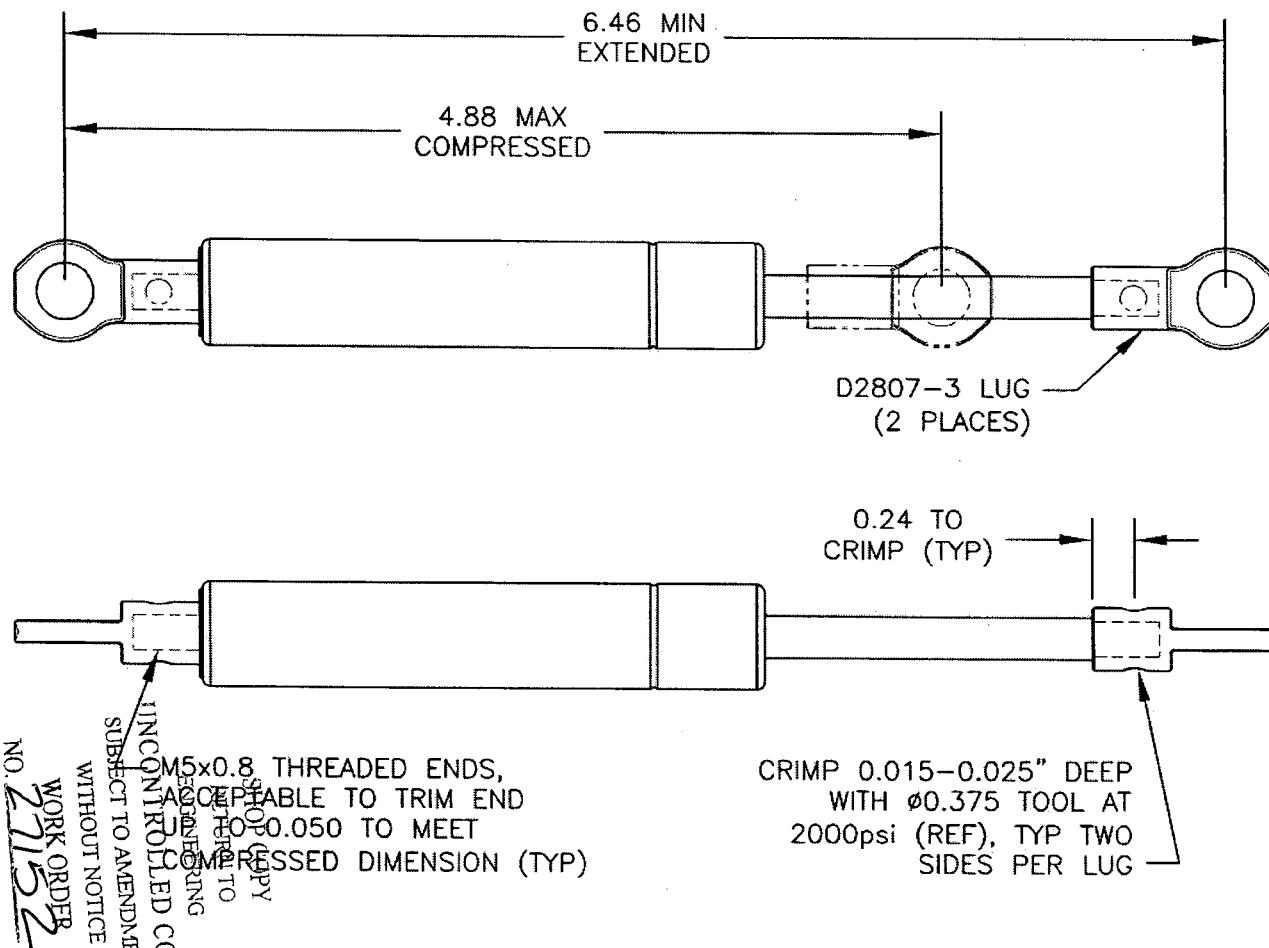
NCR: Yes No DQA: \_\_\_\_\_

Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

**DART****RELEASED**  
05.03.16**D2807 GAS SPRING**

- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

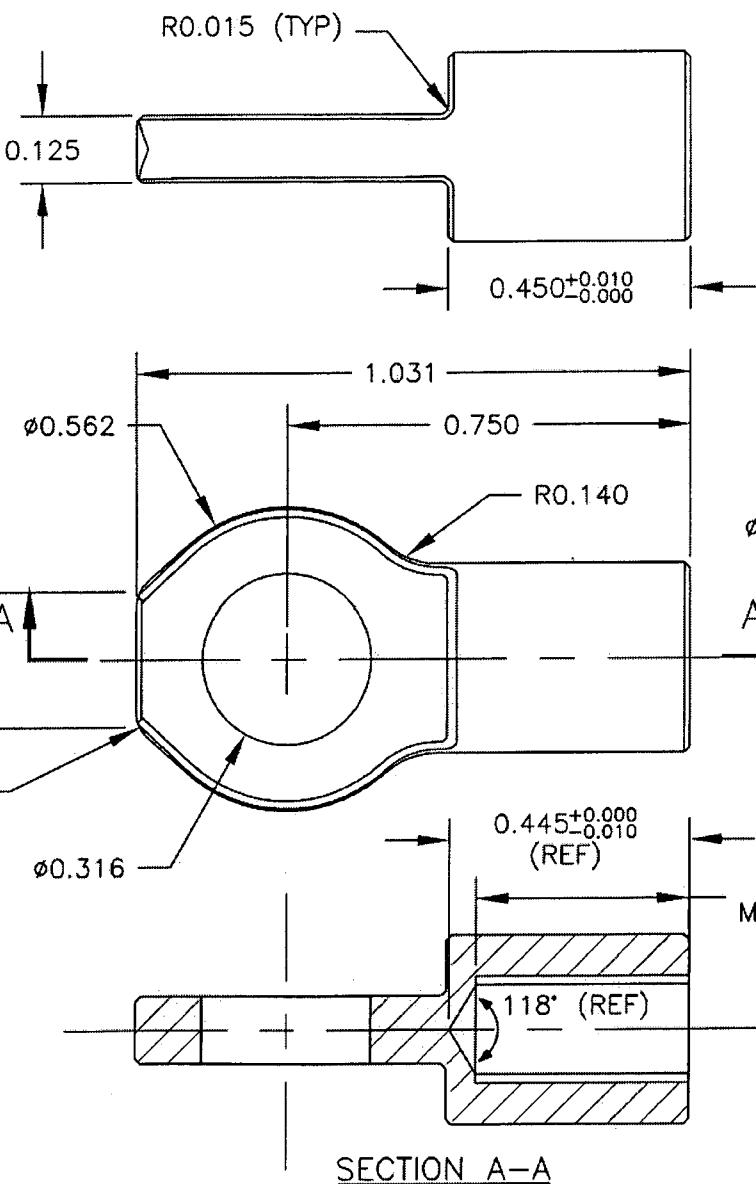
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	SHEET 1 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 1:1
A	00.11.03	NEW ISSUE	
B	05.03.16	ADD FINISH	
C	05.05.25	CHANGE SPRING TO SS, ADD - 3 LUG	

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>11</i>	APPROVED <i>11</i>	DRAWING NO. D2807
DATE 05.05.25		REV. C SHEET 2 OF 2 SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27152

DART AEROSPACE LTD	Work Order:	27152
Description: Gas spring	Part Number:	D2807-3
Inspection Dwg: 2807 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Measured by:	MS / <del>PS</del>	Audited by:	J.G	Prototype Approval:	
Date:	06/05/27	Date:	06/05/31	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	